

Date: Wednesday, 24/09/2008 12:48:02 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 42271	
Estimate Number : 10283	
P.O. Number :	Part Number : D31991
This Issue : 24/09/2008 S.O. No. :	Drawing Number : D3199 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 42223	Material :
Written By :	Due Date : 15/10/2008 Qty: 30 Um: Each
Checked & Approved By : <u>JUL 08-9-24</u>	
Comment : Est Rev:C Removed Scribing 05-11-05 JLM	
Est Rev:D As per Rev B 06-11-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.1040 sf(s)/Unit Total : 3.1185 sf(s)

304/316 0.040" SHEET

Batch: 109088 HB 8-9-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: B HB 8-9-25

Prog Rev: B

Deburr if required HB 8-9-25

(30)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-9-25

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50868/25 counter (30)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

HB 08/12/08 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 24/09/2008 12:48:02 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42271

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

508/12/08

(+30)

7.0

POWDER COATING

POWDER COATING



M109 648



(30X)

Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-30
320 OF
9-00

M-F 08/12/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-12-09

(30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(30X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 233A

8/12/09

SG

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-F 08-12-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

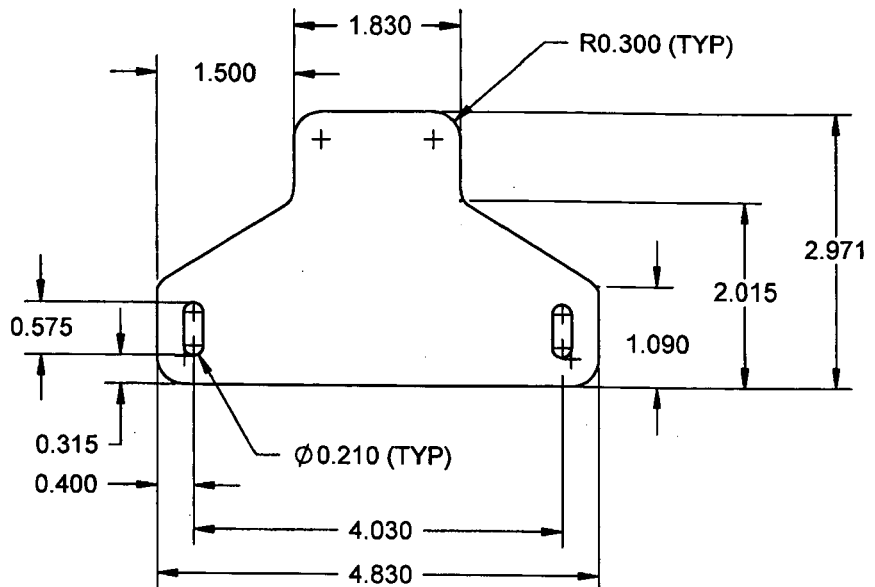
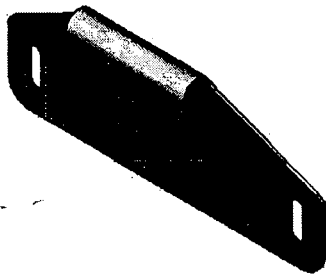
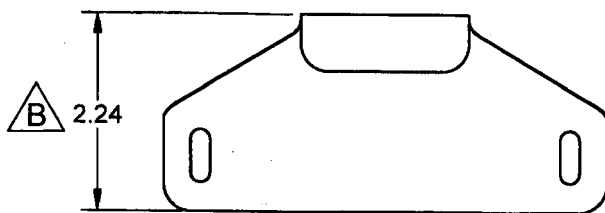
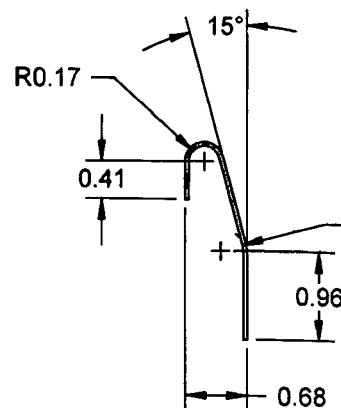
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01	TITLE BRACKET		SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED*06.11.20* *[Signature]***D3199-1 FLAT PATTERN****D3199-1 BRACKET**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42271*

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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